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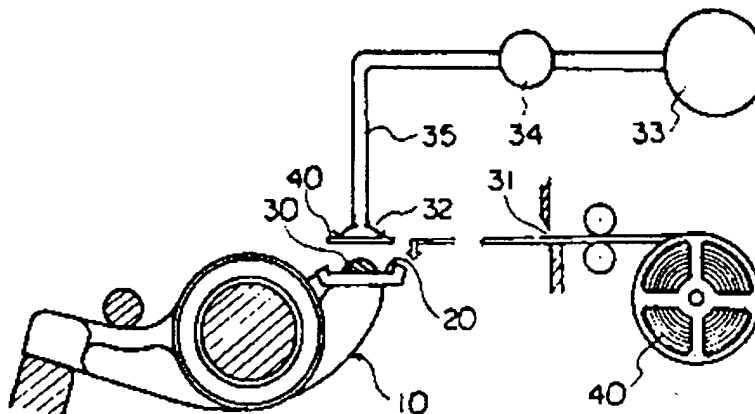
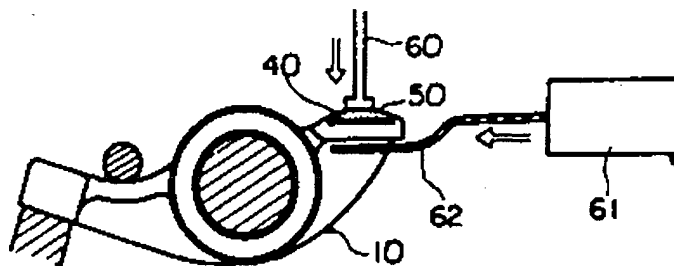
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**(54) BRAZING
METHOD OF TIP**

(57) Abstract:

PURPOSE: To obtain stable and sufficiently high brazing strength of a tip by dropping the specific amount of a flux of a controlled viscosity on an adhering surface at the time of brazing the abrasion resistant tip to the contact surface of a rocker arm with a moving valve cam.

CONSTITUTION: A rocker arm body 10 is so held and fixed that a tip brazing surface 20 prepared on its contact part 12 with a moving valve cam faces horizontal and upward. A flux 30 is dropped at a proper amount on the approximate center of the surface 20. This flux of a controlled viscosity is dropped at 0.025W0.15cc per 1cm² area of the surface 20. Desired brazing strength cannot be obtained above or below this range. Next, a flux



material 40 is supplied on this and is pressed to the surface 20 to spread with the flux. Further, a flux 30 is again dropped on the approximate center of the brazing material 40 in the manner similar to that described above and a tip 50 of abrasion resistant material is supplied thereon and is pressed to the surface 20. While the tip 50 is being pressed from thereon by the member 60, brazing is performed by a coil 62 of a high frequency heater 61.

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